

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010203**Date Inspected:** 20-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Trial Assembly Yard

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) with ABF QC utilizing scanning pattern 'D' for detecting transverse Indications on the transverse segment splice for OBG Segment 1AE to 1BE. The indications found on this date were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out.

The Weld Designations are as follows

OBE1A-007

OBE1A-006

OBE1-004

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as East line 1AE to 1BE side panel and Edge panel splice weld .

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The Weld Designation are as follows

OBE1A-007

OBE1A-006

OBE1-004

Caltrans Quality Assurance (QA) Inspector performed Ultrasonic Testing (UT) of the Transverse Segment Splice of OBG segments designated 1AE and 1BE, Side Panel Splice OBE1A-007 and Edge Panel Splice OBE1-004. The QA inspector discovered two (2) class "A" rejectable Longitudinal Linear indications in the OBE1A-007(Side Panel) weld and two (2) class "A" rejectable Longitudinal Linear indications in the OBE1-004 (Edge Panel) which the contractor failed to identify as this weld has been previously tested and accepted by the contractor.

The Y locations of the two Class "A" rejectable Longitudinal Linear indications at side panel (OBE1A-007)are as follows; Ind. #1 = 3360 mm, Ind. #2 = 6325 mm . The Y locations were taken from the corner between BP to SP longitudinal weld seam (bottom to top) at Cross Beam side.

The Y locations of the two Class "A" rejectable Longitudinal Linear indications at Edge panel(OBE1-004) are as follows; Ind. #1 = 0 mm, Ind. #2 = 1035 mm . The Y locations were taken from the corner between SP to EP longitudinal weld seam (bottom to top)at cross Beam side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
